

Work Order ID 81395

81395

Page 1

March-14-12 7:46:47 AM

Item ID: D350-636-012

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Skidtube RH

Start Date: 13/03/2012 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 27/03/2012 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/03/14 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2750

F

D3492

C

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy blue file and type labels per PPP D350-636-012 CHG 006

①

MLJ 12-05-10

for MLJ 12-5-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Start Date: 13/03/2012 Start Qty: 1.00

1

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Required Date: 27/03/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Run Start

NR1

Stop

NR2

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

110

0.00

110

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1- Pick D2600-3 Bent

2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750

3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500", deburr.

4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade fitting

5- Drill only two fwd step holes using DT9616. Ensure proper positioning.

6- Drill pilot holes as per Dwg D2750 sheet 4 (D2750-2 details). Drill using drill Jig DT8150 & DT8863A for first side only DT8863B for second side (detail K)

7- Clecko DT8863B on second side of tube and drill pilot holes for detail B.
SECOND SIDE

8-Open up holes for Detail B to 0.375" (4 holes per side) and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open up holes for ground handling and detail L to 0.500" (8 holes per side)

9-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".

10-Open up holes of Detail A to 0.297" (total of 2 holes per side)

B/GST 12-03-21

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

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Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

11-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left
from bending as per QSI 004
A/R Aluminum Rod batch: *M120854*

BE 12/04/18
12-04-19

12-Grind welds flush as per Dwg D2750

120

QC10- Inspect visual per QSI004- ground welds

0.00

120

QC

Memo

0.00

Quality Control

130

QC5- Inspect part completeness to step on W/O

0.00

130

QC

Memo

0.00

Quality Control

Dart Aerospace Ltd

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Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start ***NR1***

QC: Date: SPC (Y/N): Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
HandFinish	Memo	0.00							
Hand Finishing									
150	QC7-Inspect Chemical Conversion Coat	0.00							
150									
QC	Memo	0.00							
Quality Control									

Handwritten signature and date 12-4-20

Handwritten signature and date 12-04-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Run Start

NR1

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

0.00

160

Skidtubes

0.00

Skidtubes

Skidtubes

Memo

1- Open up holes of Detail L and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.

2- Open up holes of Detail K to 0.750" (total of 4 holes per side) as per dwg D2750.

3- Open float holes to .500" (4 per Side)

4- Chamfer holes of Detail K, L, ground handling and float holes per dwg D2750 (welding instructions on sheet 9)

5- Deburr and blow out all chips from inside of tube

6- Prepare tube for welding, remove alodine as required.

7- Bond web D2739 in place as per QSI 015

A/R Sikaflex-291

batch: 12/22/

exp. date: 13/01/04

- 12 12/04/23

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 9)

A/R Aluminum Rod

batch:

1120854 BE 12/04/24

9- At section AP-AP drill out x-bolt spacer to 0.404"

BE 12/04/24

10- Grind welds flush as per Dwg D2750 - 1205-01

11- Spot face ground handling holes section (total of 4 places per side) as per

CC 12-5-1

CF 12.4-23

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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1

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1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

dwg D2750

12-Debur holes

S/C 12-5-1

170

QC10- Inspect visual per QSI004- ground welds

0.00

170

QC

Memo

0.00

5/16/12

Quality Control

180

QC5- Inspect part completeness to step on W/O

0.00

180

QC

Memo

0.00

5/16/12

Quality Control

(Signature)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Start Date: 13/03/2012 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 27/03/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

190

Pressure Wash per QSI005 4.3

0.00

190

HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

7/6 12.5.2

200

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

200

Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

3:20 32.00F 3:50

W121134

1X 12/05/02

210

QC3- Inspect Part Finish

0.00

210

QC

Memo

0.00

Quality Control

Inspect for foreign object per QSI 024

1 12.5.2

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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March-14-12 7:46:47 AM

Item ID: D350-636-012

Accept

N9000040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Skidtube RH

Start Date: 13/03/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 27/03/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

230

0.00

230

HandFinish

Hand Finishing

HandFinishing

Memo

0.00

1-Install inserts as per dwg D2750

2-Inspect for Foreign Objects

3-Spray inside of tube with "LPS-3"

batch: N/A

4-Install blade fitting D3488-042, wearshoes and ground handling hardware as per dwg D2750

SIKA FLEX 241

BATCH: 121221

EXP DATE: 12/01

5-assemble o'ring to plug as per dwg D3492 and apply o'ring lube

A/R 55-o'ring lube batch: 110348

6-Coat all exposed fasteners with "LPS Procyon"

batch: 114546

1 RH Q (SR) 12/05/03

Dart Aerospace Ltd

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March-14-12 7:46:47 AM

Item ID: D350-636-012

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Skidtube RH

Stop

NS2

Start Date: 13/03/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 27/03/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

240

QC5- Inspect part completeness to step on W/O

0.00

240

QC

Memo

0.00

Quality Control

250

Pick Kit

0.00

250

Packaging

Memo

0.00

Packaging

260

QC4- 100% Inspect kits for completeness

0.00

260

QC

Memo

0.00

Quality Control

5.17/05/08

(X)

12/5/10

(U)

12/05/10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Start Date: 13/03/2012 Start Qty: 1.00

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Required Date: 27/03/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270		0.00							
270	Packaging								
Packaging	Memo	0.00							
Packaging	Package as per PPP D350-636-012								
280		0.00							
280	QC21- Final Inspection - Work Order Release								
QC	Memo	0.00							
Quality Control									

K

12-5-10

12/5/10

MW 12/05/10

81395

Dart Aerospace Ltd

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Picklist Print

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Page 1

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Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH

Start Date: 13/03/2012

Required Date: 27/03/2012

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev: I02.09.25 Rearranged procedure steps KJ
 IPP Rev: J 06-03-29 As per Rev D EC
 IPP Rev: K 06-07-13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC
 IPP Rev: M 08-04-22 update steps 4, 13 DD verified by: EC
 IPP Rev: N 08-09-23 rev F as per dwg DD verified by: ec IPP Rev: O
 10.06.22 revise seq 110 DD verf: EC IPP Rev: P 10.10.01 as
 per IIN rev H DD verf: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2600-3-BENT

Manufactured

No

110

Each

26.0000

1

1

D2600-3-BENT

Extrusion Bent

**

①

GST 12-03-10

Location

Loc Qty

Loc Code

LG

25

66875

7

73253

1

75021

1

75022

1

75023

1

81330

14

D2744

Manufactured

No

110

Each

60.0000

1

1

D2744

Cap

**

BE 12/04/18

Location

Loc Qty

Loc Code

LG002

60

62715

1

70881

10

71861

7

78900

42

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH

Start Date: 13/03/2012

Required Date: 27/03/2012

Start Qty: 1.00

Required Qty: 1.00

D2739

Manufactured No

160

Each

8.0000

1

1

D2739

350 I Beam

**

DC 12/14/23

Location 1383548

Loc Qty

Loc Code

LG

8

72155

1

80083

7

(1)

D2743

Manufactured No

160

Each

248.0000

8

8

D2743

Crossbolt Spacer

**

★

BE12/04/24
BB1965 *8

Location

Loc Qty

Loc Code

LG001

248

67766

4

68251

3

73403

64

74445

1

78603

76

79517

100

D3490-3

Manufactured No

160

Each

38.0000

4

4

D3490-3

Cross Bolt Spacer

**

BE12/04/24
BB2016 *4

Location

Loc Qty

Loc Code

LG001

38

78800

38

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item: D350-636-012

Parent Item Name: Skidtube RH

81395

D350-636-012

Start Date: 13/03/2012

Required Date: 27/03/2012

Start Qty: 1.00

Required Qty: 1.00

D3490-1

Manufactured No

160

Each

49.0000

4

4

D3490-1

Cross Bolt Spacer

**

BE 12/04/24
81976 24

Location

Loc Qty

Loc Code

LG001

49

62450

2

74875

4

77042

3

78793

40

D3631-1

Manufactured No

230

Each

223.0000

8

8

D3631-1

Washer

**

8

DP 12/05/02

Location

Loc Qty

Loc Code

ST072

223

68062

2

75548

221

D3791-1

Manufactured No

230

Each

17.0000

1

1

D3791-1

Wearplate

**

1

DP 12/05/02

Location

Loc Qty

Loc Code

FP002

17

62239

2

75041

3

78897

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 4

Work Order ID: 81395

81395

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH

Start Date: 13/03/2012

Required Date: 27/03/2012

Start Qty: 1.00

Required Qty: 1.00

D3793-3

Manufactured No

230 Each

26.0000 1 1

D3793-3

Wearshoe

**

1 DP 12/05/02



Location

Loc Qty

Loc Code

FP001

83394✓

12

80434

12

FP002

14

78935

14

MS21043-6

Purchased No

230 Each

809.0000 4 4

MS21043-6

NUT

**

4 DP 12/05/02

Location

Loc Qty

Loc Code

FG

20

103693

20

ST301

789

112314

83

117887

6

118384✓

200

120308

500

D3794-1

Manufactured No

230 Each

24.0000 1 1

D3794-1

Gasket

**

1 DP 12/05/02

Location

Loc Qty

Loc Code

FP002

82167✓

24

75042

12

80435

12

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 81395

81395

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH

Start Date: 13/03/2012

Required Date: 27/03/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1611-010

Purchased

No

230

Each

209.0000

8

8

NAS1611-010

O-RING

**

8 DP 12/05/02

Location

Loc Qty

Loc Code

FP	121415 ✓	50
	110915	0
	120770	50
FP001		159
	110915	14
	117460	8
	118077	1
	118612	3
	119438	47
	120308	36
	120986	50

D2741

Manufactured

No

250

Each

37.0000

1

1

D2741

Blade, 350 Skidtube

**

BA516 12/5/9 DP

Location

Loc Qty

Loc Code

ST		-10
ST466		47
	71856	1
	76984	36

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 81395

81395

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH

Start Date: 13/03/2012

Required Date: 27/03/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1515H3L

Purchased

No

230

Each

184.0000

4

4

***NAS1515H3I ***

WASHER

**

4

(DP)

12/05/02

Location

Loc Qty

Loc Code

FG

121243 ✓

40

102472

40

ST277

144

118686

3

119438

1

120072

40

120360

100

NAS1611-013

Purchased

No

230

Each

168.0000

8

8

NAS1611-013

O-RING

**

8

(DP)

12/05/02

Location

Loc Qty

Loc Code

FP001

121584 ✓

168

116582

5

117291

2

117887

53

119623

36

120360

22

120910

50

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 81395

81395

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH

Start Date: 13/03/2012

Required Date: 27/03/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C6A

Purchased

No

230

Each

623.0000

4

4

AN3C6A

BOLT

**

4

(2P)

12/05/02

Location

Loc Qty

Loc Code

FP001

1

111982

1

ST351

622

111982

2

116419

23

116549

2

116704

12

117619

10

117688

1

117872

5

118422

13

119449

21

120423

133

120693 ✓

400

NAS1149C0832R

Purchased

No

230

Each

304.0000

1

1

NAS1149C0832R

WASHER

**

1

(2P)

12/05/02

Location

Loc Qty

Loc Code

ST297

304

114915 ✓

304

D3536-25

Manufactured

No

230

Each

16.0000

1

1

D3536-25

Gasket

**

1

(2P)

12/05/02

Location

Loc Qty

Loc Code

FP002

16

78902

16

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 81395

81395

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH

Start Date: 13/03/2012

Required Date: 27/03/2012

Start Qty: 1.00

Required Qty: 1.00

D3794-3

Manufactured No

230

Each

31.0000

1

1

D3794-3

Gasket

**

1 (2P) 12/05/02

Location

Loc Qty

Loc Code

FP002

31

74530

2

78895

5

80436 ✓

24

AN3C5A

Purchased No

230

Each

998.0000

34

34

AN3C5A

Bolt

**

34 (2P) 12/05/02

Location

Loc Qty

Loc Code

FP001

7

115835

7

ST350

991

116419

28

117343

13

117764

7

117872

2

119749

23

120423

918

D3537-1

Manufactured No

230

Each

151.0000

3

3

D3537-1

Wearpad

**

3 (2P) 12/05/02

Location

Loc Qty

Loc Code

FP001

104

79833

50

79835

54

FP002

47

69817

5

79834

42

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 81395

81395

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH

Start Date: 13/03/2012

Required Date: 27/03/2012

Start Qty: 1.00

Required Qty: 1.00

D3535-25

Manufactured No

230 Each

19.0000 1 1

D3535-25

Wearshoe

**

1

(2P) 12/05/02

Location	Loc Qty	Loc Code
FP001 82156✓	14	
62233	1	
80331	13	
FP002	5	
77617	5	

D3492-3

Manufactured No

230 Each

69.0000 8 8

D3492-3

Plug

**

8

(2P) 12/05/02

Location	Loc Qty	Loc Code
FP-A 83099✓	69	
78600	69	

AN960C10L

Y NAS1149C0332✓ Purchased No

230 Each 0.0000 38 38

*AN960C10I *

washer

121509

**

38

(2P) 12/05/02

D3488-042

Manufactured No

230 Each 19.0000 1 1

D3488-042

Blade Fitting Assembly, RH

**

1

(2P) 12/05/02

Location	Loc Qty	Loc Code
FP002	19	
62003	1	
75068✓	9	
77015	9	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 81395

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

81395

D350-636-012

Start Date: 13/03/2012

Required Date: 27/03/2012

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-225

Purchased

No

230

Each

1,134.000

38

38

AI S4-1032-225

Insert

**

38

(28)

12/05/02

Location

Loc Qty

Loc Code

ST281

12/26/02

1021

108696

146

110768

62

118386

55

118966

68

120671

690

ST282

113

120410

100

120451

13

D3492-1

Manufactured

No

230

Each

130.0000

8

8

D3492-1

Plug

**

8

(28)

12/05/02

Location

Loc Qty

Loc Code

FP002

83098

130

69531

8

74444

2

76235

20

77037

100

D3793-1

Manufactured

No

230

Each

18.0000

1

1

D3793-1

Wearshoe

**

1

(28)

12/05/02

Location

Loc Qty

Loc Code

FP001

2271

18

77029

6

78901

12

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 11

Work Order ID: 81395

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

81395

D350-636-012

Start Date: 13/03/2012

Required Date: 27/03/2012

Start Qty: 1.00

Required Qty: 1.00

AN8C35A

Purchased

No

230

Each

65.0000

1

1

AN8C35A

BOLT

**

1

(2P)

12/05/02

Location

Loc Qty

Loc Code

FP002

64

115960

1

117834

10

118286 ✓

53

ST346

1

114442

0

115188

0

115960

1

MS21083C8

Purchased

No

230

Each

85.0000

1

1

MS21083C8

NUT

**

1

(2P)

12/05/02

Location

Loc Qty

Loc Code

FP002

1

115884

1

ST303

14

115884

0

118077

1

119309

2

119436

9

119638

2

ST304

70

120142

20

120731

25

121011

25

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

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Page 12

Work Order ID: 81395

81395

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH

Start Date: 13/03/2012

Required Date: 27/03/2012

Start Qty: 1.00

Required Qty: 1.00

D2745

Manufactured No

230

Each

136.0000

8

8

D2745

Bushing

**

8

(2P)

12/05/02

Location

Loc Qty

Loc Code

FP

83260 ✓

100

79518

100

FP001

36

69529

1

76142

1

78597

34

AN6C44A

Purchased No

230

Each

107.0000

4

4

AN6C44A

BOLT

**

4

(2P)

12/05/02

Location

Loc Qty

Loc Code

FG

121167 ✓

2

103964

2

ST343

105

120095

12

120143

25

120465

27

120641

21

121013

20

D3532-1

Manufactured No

250

Each

39.0000

2

2

D3532-1

Spacer

**

B82041

12/5/02

(2P)

Location

Loc Qty

Loc Code

ST053

39

78839

39

March-14-12 7:46:50 AM

Shop Packet Print

Page 12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

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Page 13

Work Order ID: 81395

81395

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH

Start Date: 13/03/2012

Required Date: 27/03/2012

Start Qty: 1.00

Required Qty: 1.00

MS21083C8

Purchased

No

250

Each

85.0000

2

2

MS21083C8

NUT

**

M121524 SP

Location

Loc Qty

Loc Code

FP002

1

115884

1

ST303

14

115884

0

118077

1

119309

2

119436

9

119638

2

ST304

70

120142

20

120731

25

121011

25

NAS1149D0863J

Purchased

No

250

Each

231.0000

2

2

NAS1149D0863J

WASHER

**

SP

Location

Loc Qty

Loc Code

ST298

231

118078

36

119307

95

120308

100

2

D3493-1

Manufactured

No

250

Each

66.0000

2

2

D3493-1

Washer

**

B82023 12/5/10

Location

Loc Qty

Loc Code

ST050

66

70697

2

77573

24

78835

40

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Shop Packet Print

Page 13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

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Page 14

Work Order ID: 81395

81395

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH

Start Date: 13/03/2012

Required Date: 27/03/2012

Start Qty: 1.00

Required Qty: 1.00

AN8C21A

Purchased

No

250

Each

51.0000

2

2

 *AN8C21A*

BOLT

**

M121167

12/5/10 [Signature]

Location

Loc Qty

Loc Code

ST343

51

118758

5

120094

42

120872

4

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH:
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ($\phi 0.297$) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 81395MLJ

12/03/14

RELEASED

F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS, CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741, QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	PC	DART AEROSPACE USA, INC.	
DRAWN	RL	PORT HADLOCK, WA	
CHECKED	AS	DRAWING NO.	REV. F
MFG. APPR.	AS	D2750	SHEET 1 OF 11
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DE APPR.	AS	350 SKIDTUBE ASSEMBLY	NTS
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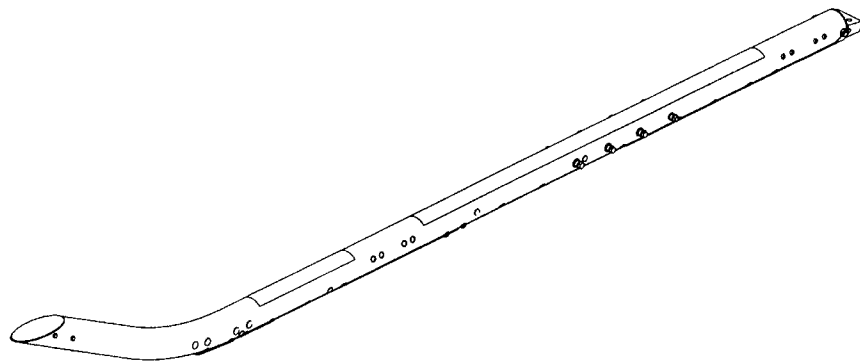
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR: Yes No** **DQA:** _____ **Date:** _____
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

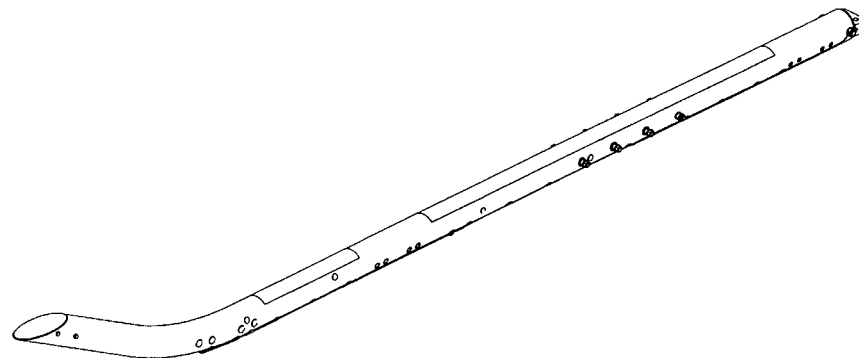
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

81395



D2750-041 350 SKIDTUBE ASSEMBLY, LH



D2750-042 350 SKIDTUBE ASSEMBLY, RH

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08.07.16

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

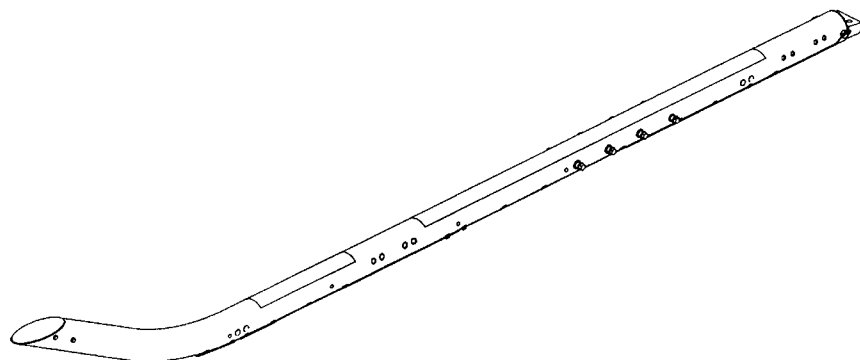
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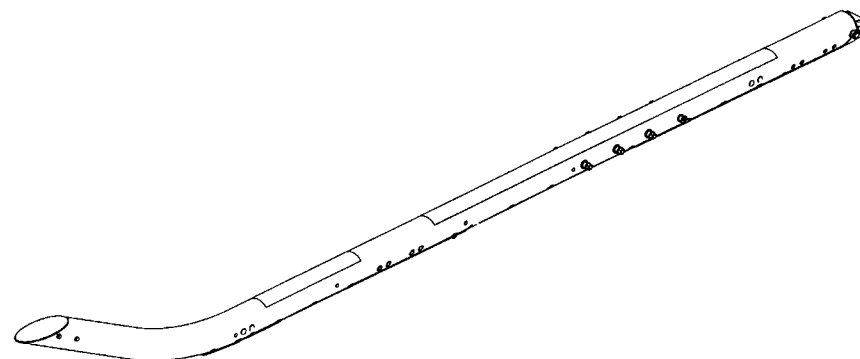
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

81395



D2750-043 350 SKIDTUBE ASSEMBLY, LH



D2750-044 350 SKIDTUBE ASSEMBLY, RH

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68-9-22/100

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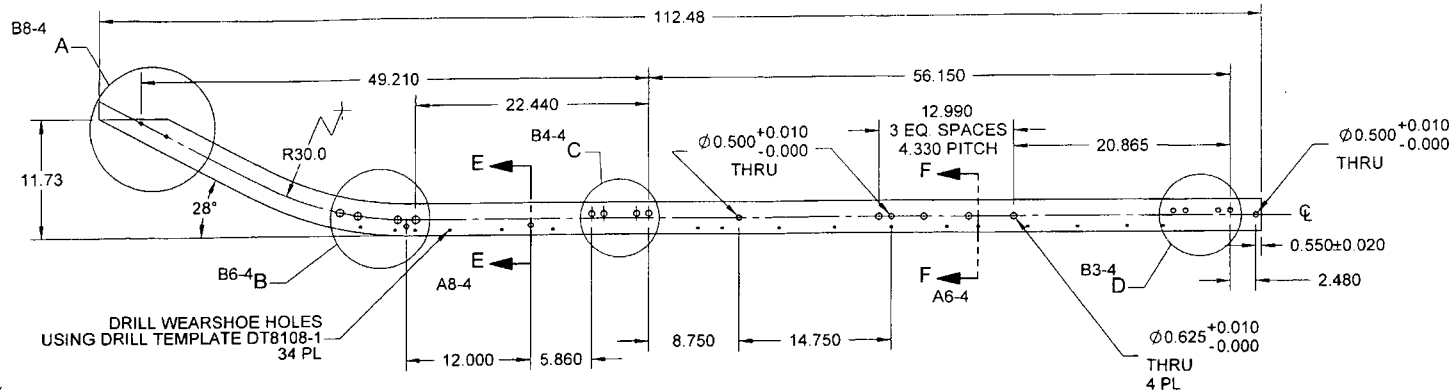
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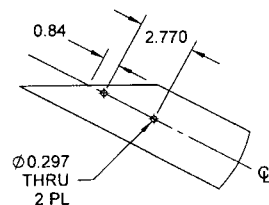
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

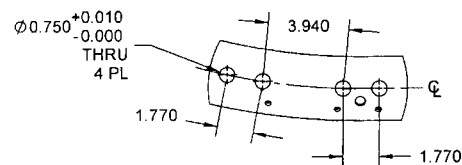
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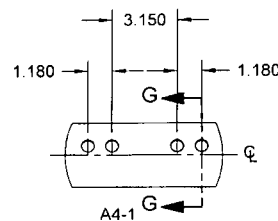
D2750-1 LH SKIDTUBE



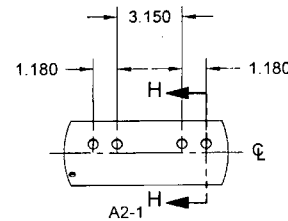
DETAIL A
SCALE 2X



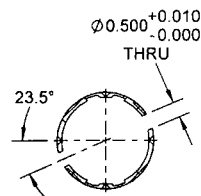
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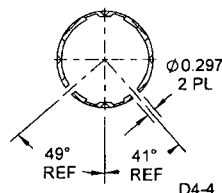
DETAIL C
SCALE 2X



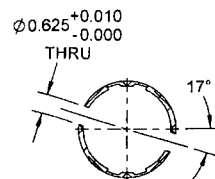
DETAIL D
SCALE 2X



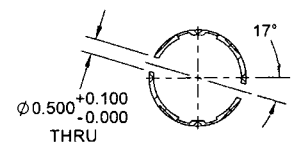
SECTION E-E
SCALE 3X, 2 PL



SECTION F-F
SCALE 3X, 17 PL



SECTION G-G
SCALE 3X, 4 PL



SECTION H-H
SCALE 3X, 4 PL

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

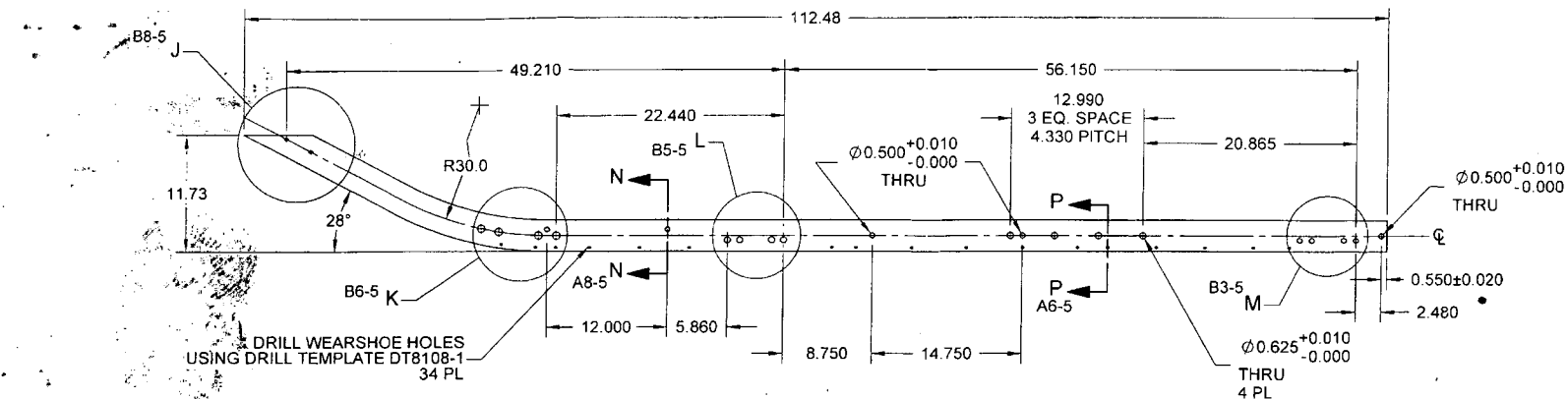
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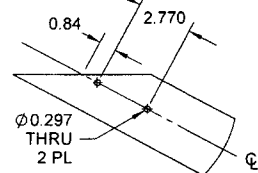
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

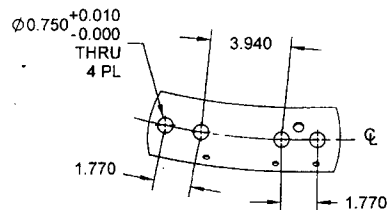
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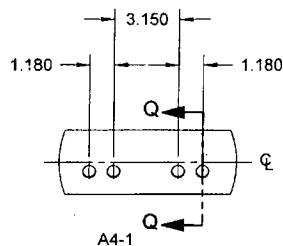
D2750-2 RH SKIDTUBE



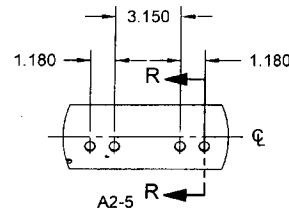
DETAIL J
SCALE 2X



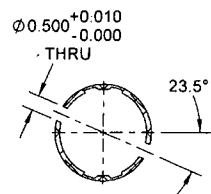
DETAIL K
SCALE 2X



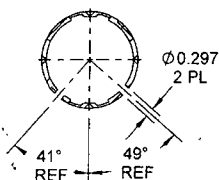
DETAIL L
SCALE 2X



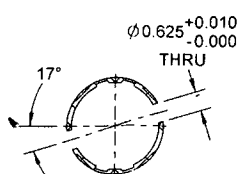
DETAIL M
SCALE 2X



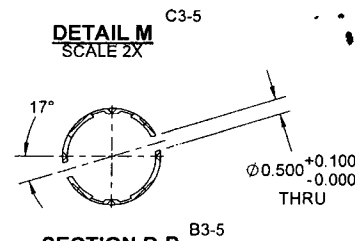
SECTION N-N
SCALE 3X, 2 PL



SECTION P-P
SCALE 3X, 17 PL



SECTION Q-Q
SCALE 3X, 4 PL



SECTION R-R
SCALE 3X, 4 PL

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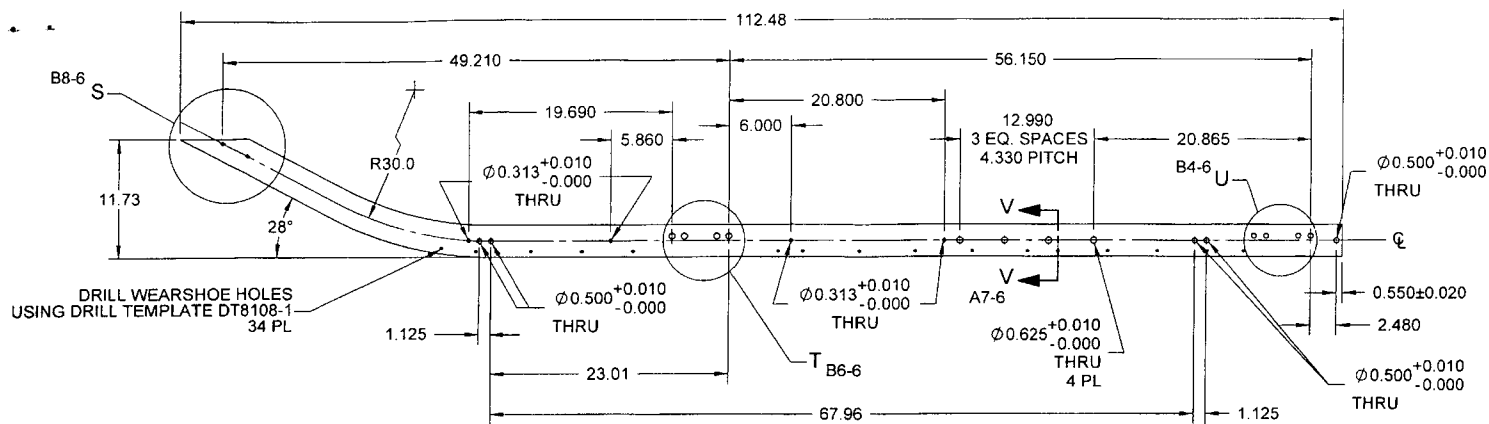
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

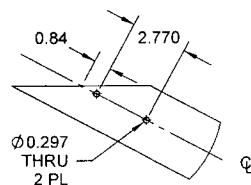
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

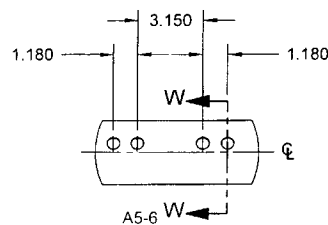
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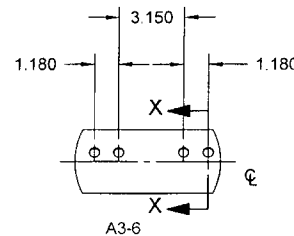
D2750-3 LH SKIDTUBE



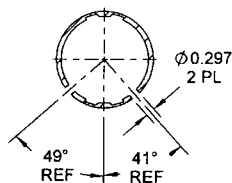
DETAIL S
SCALE 2X
D8-6



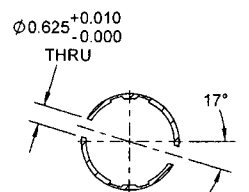
DETAIL T
SCALE 2X
C5-6



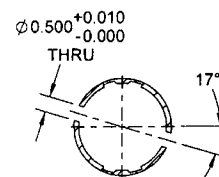
DETAIL U
SCALE 2X
D3-6



SECTION V-V
SCALE 3X, 17 PL
C4-6



SECTION W-W
SCALE 3X, 4 PL
B6-6



SECTION X-X
SCALE 3X, 4 PL
B4-6

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DESIGN		DART AEROSPACE USA, INC.	
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CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2750	SHEET 6 OF 11
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

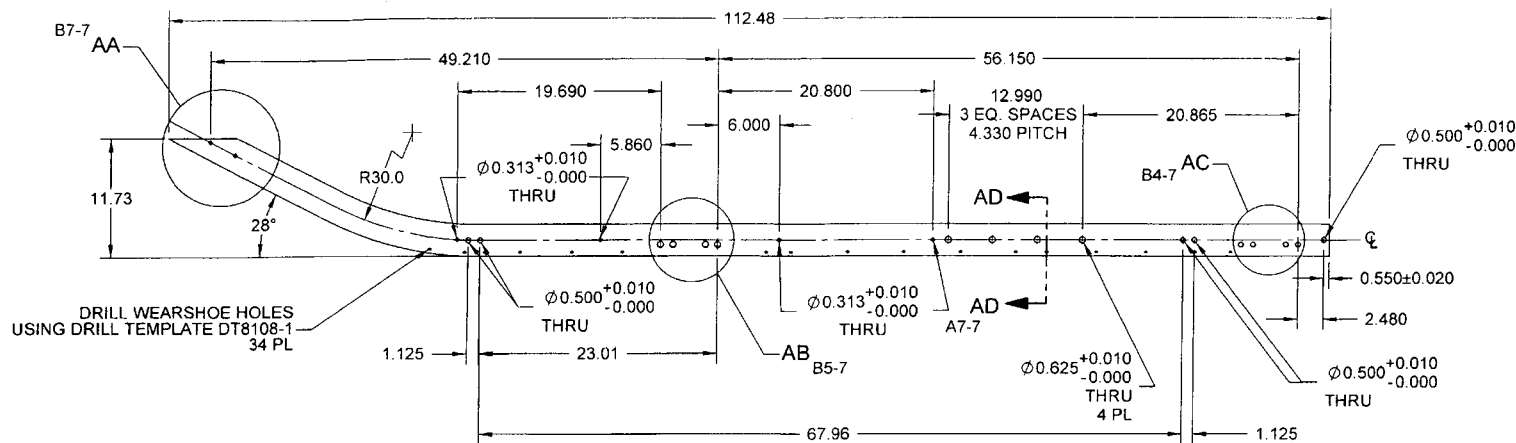
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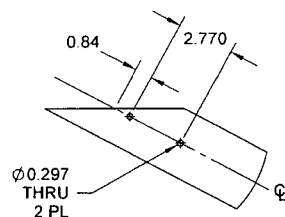
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

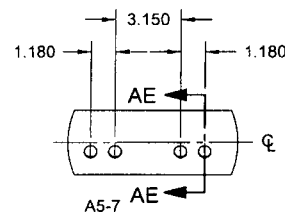
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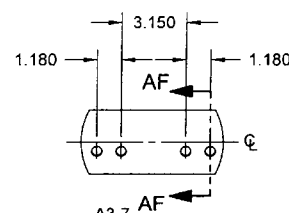
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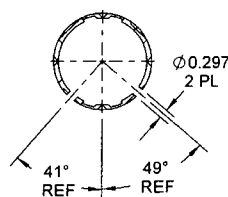
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SCALE 2X



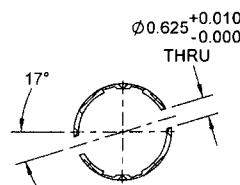
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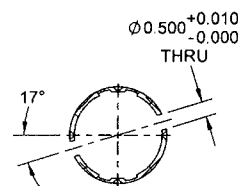
DETAIL AC
SCALE 2X



SECTION AD-AD
SCALE 3X, 17 PL



SECTION AE-AE
SCALE 3X, 4 PL



SECTION AF-AF
SCALE 3X, 4 PL

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

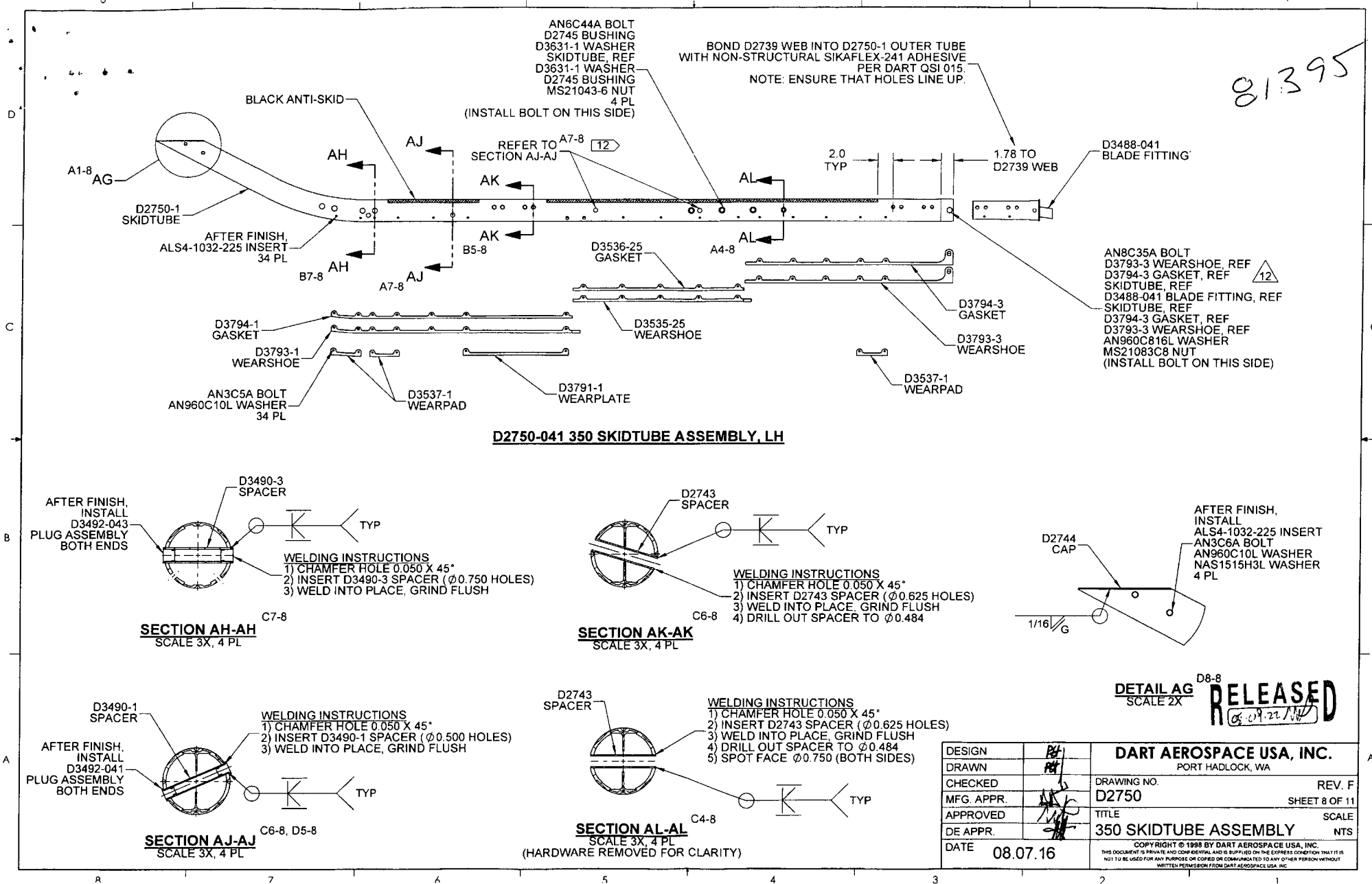
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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DESIGN	BA	DART AEROSPACE USA, INC.	
DRAWN	BA	PORT HADLOCK, WA	
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MFG. APPR.	BA	D2750	SHEET 8 OF 11
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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NOTE: Date & initial all entries

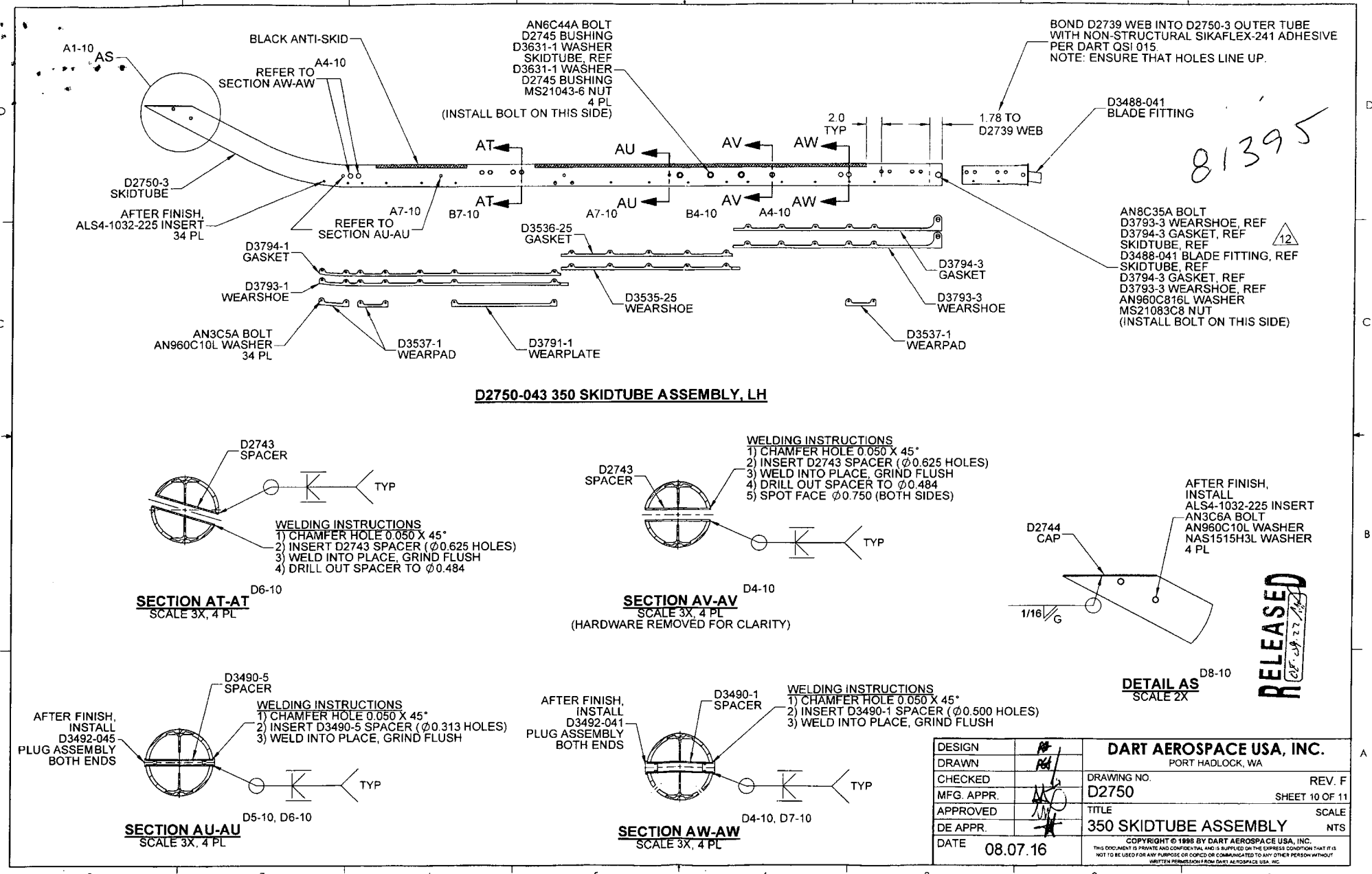
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D2750-043 350 SKIDTUBE ASSEMBLY, LH

SECTION AT-AT
SCALE 3X, 4 PL

SECTION AV-AV
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)

SECTION AU-AU
SCALE 3X, 4 PL

SECTION AW-AW
SCALE 3X, 4 PL

DETAIL AS
SCALE 2X

DESIGN	PORT HADLOCK, WA	DART AEROSPACE USA, INC.
DRAWN		
CHECKED		DRAWING NO. D2750
MFG. APPR.		REV. F
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DE APPR.		TITLE SCALE
DATE	08.07.16	350 SKIDTUBE ASSEMBLY NTS

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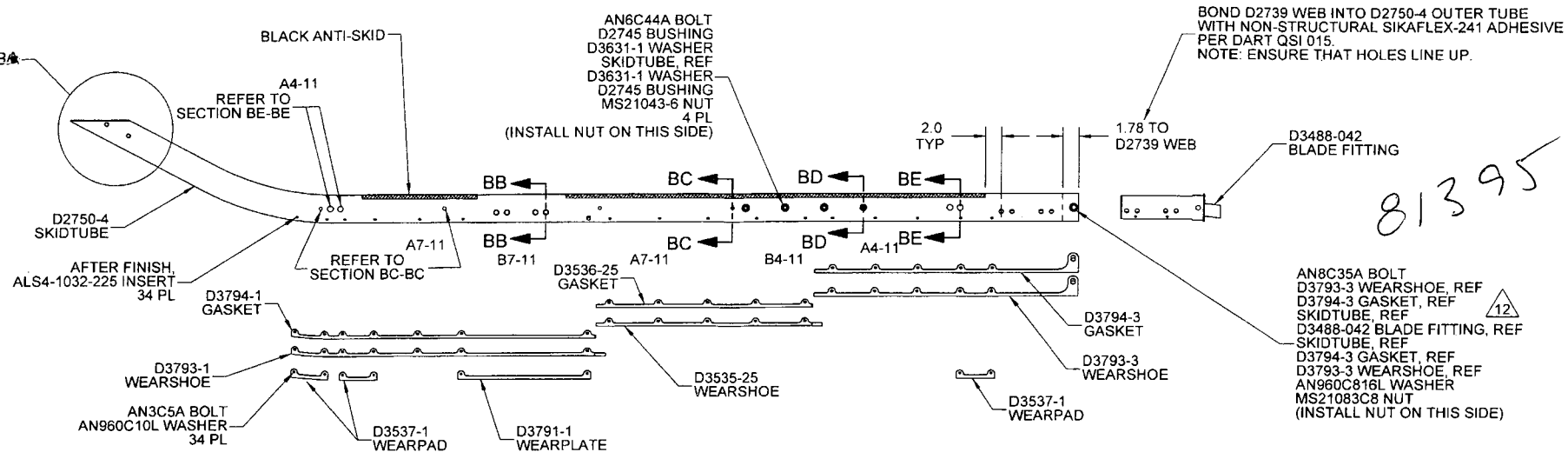
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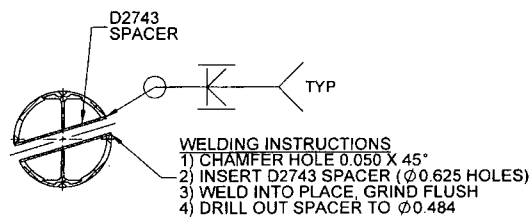
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

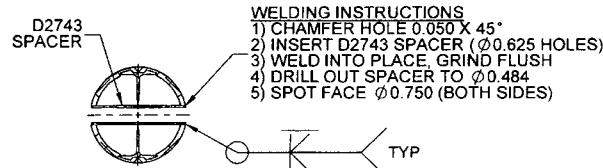
NOTE: Date & initial all entries



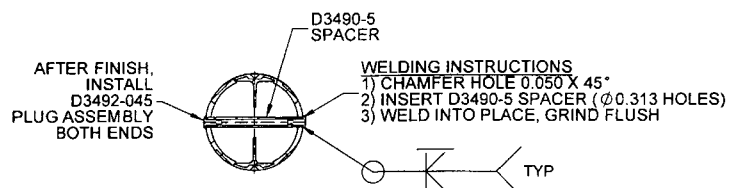
D2750-044 350 SKIDTUBE ASSEMBLY, RH



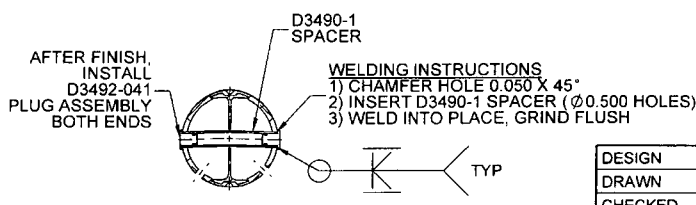
SECTION BB-BB SCALE 3X, 4 PL



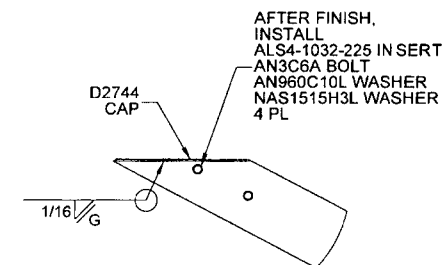
SECTION BD-BD SCALE 3X, 4 PL (HARDWARE REMOVED FOR CLARITY)



SECTION BC-BC SCALE 3X, 4 PL



SECTION BE-BE SCALE 3X, 4 PL



DETAIL BA SCALE 2X

DESIGN	PH	DART AEROSPACE USA, INC.	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2750	SHEET 11 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 293

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 82796
Part number: A350-636-014
Description: Skid tube
Welding Process: Tig[☒] Mig[☐]
Base material: Alum
Current: AC[☒] DC[☐]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[☐]
Penetration: pass[☒] fail[☐]

UNACCEPTABLE

Cracks: pass[☒] fail[☐]
Undercut: pass[☒] fail[☐]
Pin holes: pass[☒] fail[☐]
Overlap (cold lap): pass[☒] fail[☐]
Porosity (surface): pass[☒] fail[☐]
Coloration: pass[☒] fail[☐]

Qualifier David Reed Date of Test Coupon 12-05-01

Welder Barclay Elliott Date of Test Coupon 12-05-01

The above named individual is qualified in accordance with AWS D17.1.2001 to weld